

Date: Monday, 3/27/2006 10:00:46 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 26364		
Estimate Number	: 10178		
P.O. Number	: NIA	Part Number	: D25941
This Issue	: 3/27/2006 S.O. No. : NIA	Drawing Number	: D2594 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/23/2006 Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 25593	Material	: NIA
Written By	: <u>See Comment Below</u>	Due Date	: 4/10/2006
Checked & Approved By	: <u>06.03.24</u>	Qty:	500 Um: Each
Comment	: Est D 02.08.22 Make in Cobra KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch <u>M19712</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. <u>Deburr. M.F. 06/07/05</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>M8 06/06/25</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>J.F. 06/06/29</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 <u>SAD 06:07:08</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/08/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



SC 06/07/28 (100)
VSC 06/08/03 407



(507)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/08/06 (507)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 15

DL 06/08/06 (507)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/08/09 (507)

Job Completion



W 06.08.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

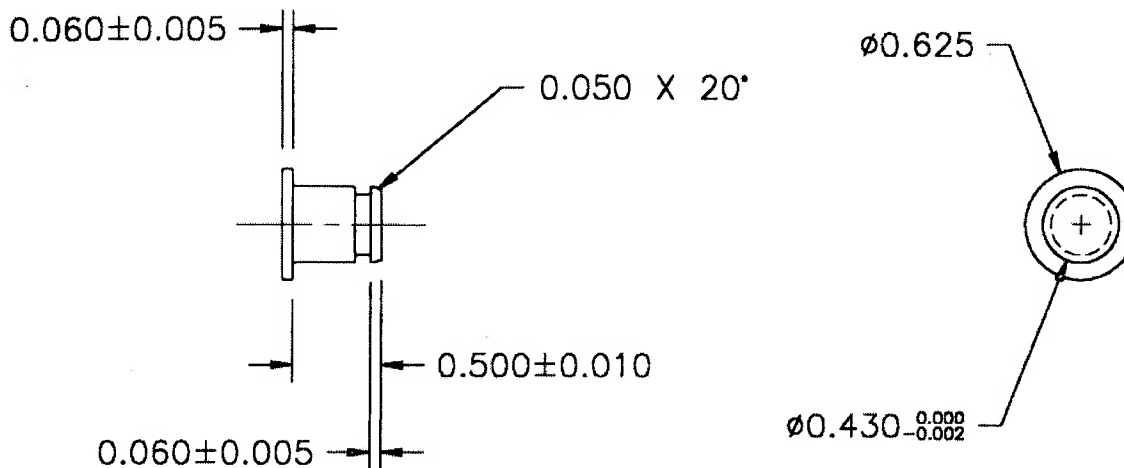
NOTE: Date & initial all entries



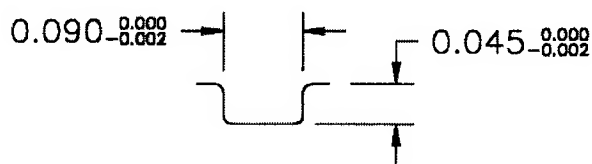
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02-08-26	ADD POWDER COAT, QSI 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 PS



GROOVE DETAIL (SCALE 5:1)



TOOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-0

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.5.1) PER QSI COS 4.3

PER QQ-A-225 / 7 (5052)
OR QQ-A-225 / 8 (6061)
OR QQ-A-225 / 1 (1100)
OR QQ-A-200 / 8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES: (1) D2594-1 PLUG
(1) D2594-3 O-RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26364